

Date: Thursday, 7/17/2008 7:48:35 AM
 User: David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE (AFT)
 Job Number : 05033
 Estimate Number : 13466
 P.O. Number :
 This Issue : 7/17/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D38053
 First Issue : // Type : R & D SM/MED FAB Drawing Number : D3805 PROTO
 Previous Run : Material :
 Written By : MS/07/17 Due Date : 7/24/2008 Qty: 2 Um: Each
 Checked & Approved By :
 Comment : Est Rev:A 08-07-15 new issue DD verified by:EC

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 M304S18GA 304/316 .050 Sheet



Comment: Qty.: 0.9554 sf(s)/Unit Total : 1.9108 sf(s)

304/316 .050 Sheet

batch: 108156 HB 8-7-16

Scrap new design

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3805-1F

Dwg Rev: PROTOProg Rev: PROTO

HB 8-7-16

2-Deburr if necessary

HB 8-7-16

(3)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-7-16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

NC BRAKE

5.0 BRAKE NC



Comment: NC BRAKE

Form as per Dwg D3805 using Jigs DT8261 and DT8326

SR 08/07/17 (3)

Date: Thursday, 7/17/2008 7:48:36 AM
User: David Duval

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE (AFT)

Job Number: 05033

Part Number: D38053

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5



INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



P (3)
08.07.17

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FOR ENGINEERING USE ONLY

Identify and Check

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



change to W/O # 00255A

MF 08-08-08

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D206-642

Job #: 00255A

Date: 08.07.16

Product Name: Wearplate

Requested By: CP

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3805-1	GA	FWD PLATE	08.07.16	N	ASAP	BEND FROM D3805-1F, BEND RADS SAME AS D3535	
2	D3805-3	GA	AFT PLATE	08.07.16	N	ASAP	BEND FROM D3805-1F, BEND RADS SAME AS D3535	

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D206-642

Job #: 00255A

Date: 08.07.15

Product Name: Wearplate

Requested By: CP

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
4	D3805-1F	GA	Flat Pattern	08.07.15	Y	ASAP	Flat pattern for D3805-1 and D3805-3	

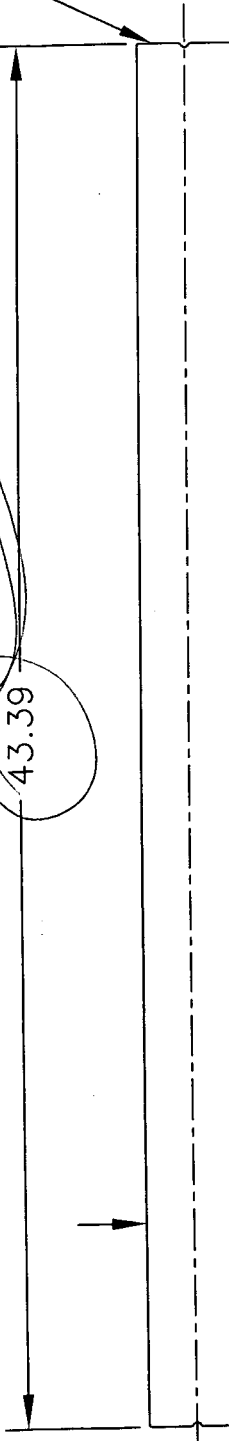
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3805	REV. A SHEET 1 OF 1
DATE 08.07.15	TITLE WEARPLATE ASSEMBLY		SCALE NTS
A	08.07.15	NEW ISSUE	

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

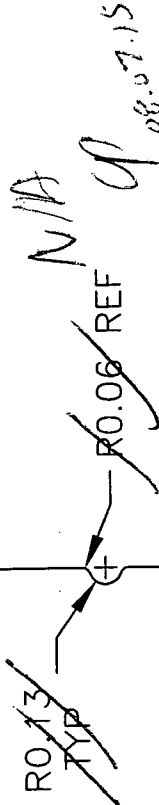
08.07.15

D3805-1F FLAT PATTERN

SEE
DETAIL
A



R0.06 TYP



DETAIL A

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK)
(REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:

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DART AEROSPACE LTD		Work Order:	40509
Description: WEAR PLATE		Part Number:	D3805-1
Inspection Dwg: D3805-1 Rev: PROTO TYPE			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**[illegible]

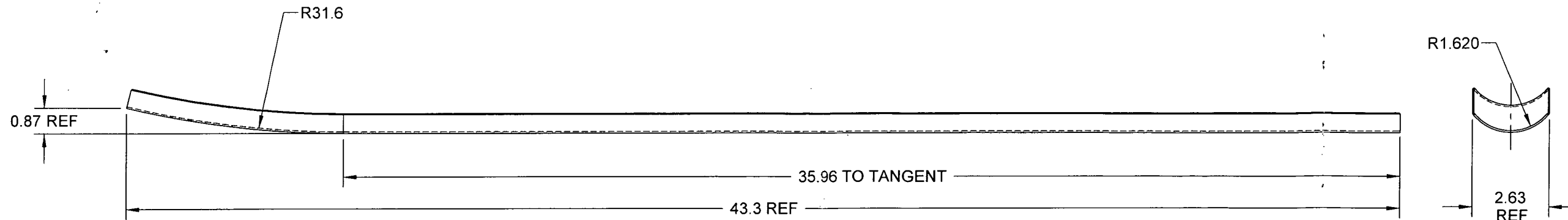
Measured by:	BB	Audited by:		Prototype Approval:	
Date:	8-7-16	Date:	080717	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

D

D



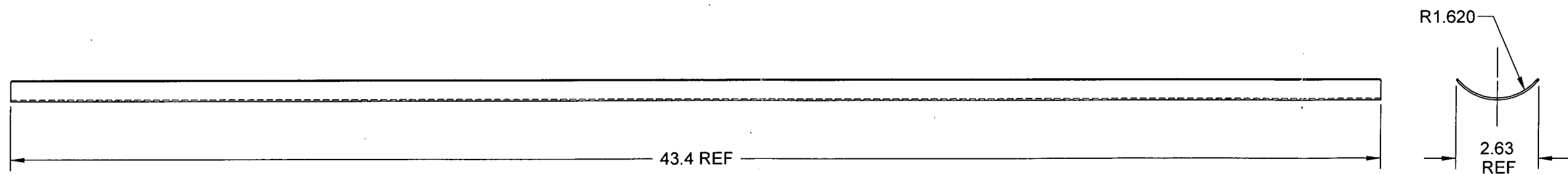
D3805-1 FWD PLATE

C

C

B

B



D3805-3 AFT PLATE

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.07.16

NOTES:

- 1) MATERIAL: MAKE D3805-1 & D3805-3 FROM D3805-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-1" OR "D3806-3" (AS APPROPRIATE) USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-1 = 1.85 lbs
D3805-3 = 1.85 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3805	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	08.07.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1